

Work Order ID 73981

Tuesday, September 20, 2011 10:23:51 AM



Page 1

Item ID:	D2432	Accept		Setup	Start	
Revision ID:						
Item Name:	206 (24") Bearpaw				Stop	
Start Date:	9/20/2011	Start Qty:	12.00			
Required Date:	10/4/2011	Req'd Qty:	12.00			
Reference:						

Approvals:	Process Plan:	<i>mf</i>	Date:	11-09-20	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2432	Rev F3								

120		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	Cut Blank as per D2432 File								

11-9-30

(12)

130		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr								

SL 11-11-28

(PTO) →

140		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

SL 11-11-28

11

W/O: 7398)		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2432 PAR #: N/A Fault Category: Machining NCR: Yes No DQA: Just Date: 11/11/29
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: R Date: 11/11/30

NCR: 11-031		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-11-28	130	1 part scraped - Forget to put bolts in order to hold part, part moved and has deep marks	<u>EB</u> 05/11/28	- scrap + no replace	<u>SK</u> 11-11-28	<u>enf</u> 11/11/28	<u>EB</u> 05/11/28	<u>m/h</u> 11/11/28
		R.C. LOA						
		PROCESS CONTROL MISSING INSPECTION PROCESS						

NOTE: Date & initial all entries

Work Order ID 73981

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Tuesday, September 20, 2011 10:23:51 AM

Item ID: D2432

Accept



Setup Start



Revision ID:

Stop



Item Name: 206 (24") Bearpaw

Start Date: 9/20/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/4/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC8- Inspect parts - second check

0.00

*OK 11/11/28**11**8*

QC

Memo

0.00

Quality Control

151

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

*PPG 3980**11/11/28*

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/11/28**MF 11-11-28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, September 20, 2011 10:23:49 AM

Page 1

Work Order ID: 73981



Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 12.00

Required Qty: 12.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	623.6200	3.7	44.4			



UHMW 1" Black



1311-9-30

Location

Loc Qty

Loc Code

MAT018

383.62

117321

76.6

117738

124.3

117819

99.3

118257

83.42

ST

240

118814

240

118814

(12)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 73981
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432	Rev: F3	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.065 x 45°	/		
B	5.500	+/-0.030	5.505	/		
C	0.200	+/-0.030	.192	/		
D	0.25 x 45°	+/-0.030	.25 x 45°	/		
E	R0.250	+/-0.030	.250	/		
F	0.250	+/-0.010	.242	/		
G	0.625	+/-0.030	.610	/		
H	0.375	+/-0.010	.368	/		
I	0.950	+0.030/0.010	.942	/		
J	19.000	+/-0.030	19.00	/		
K	3.14	+/-0.030	3.14	/		
L	3.28	+/-0.030	3.28	/		
M	Ø0.260	+0.005/-0.000	.260	/		
N	Ø0.93	+/-0.030	.926	/		
O	0.30	+0.030/-0.000	.311	/		
P	23.750	+/-0.030	23.750	/		
Q	7.375	+/-0.030	7.374	/		
R	4.250	+/-0.010	4.250	/		
S	2.000	+/-0.030	2.015	/		
T	9.000	+/-0.010	9.000	/		
U	9.000	+/-0.010	9.000	/		
V	0.375	+/-0.010	.378	/		

Measured by: <u> J </u>	Audited by: <u> mf </u>	Prototype Approval:	N/A
Date: 11-11-26	Date: 11/11/28	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF <u> J </u>

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY CORE DIMS Ø RF

RELEASED
98.06.17 KE

DART

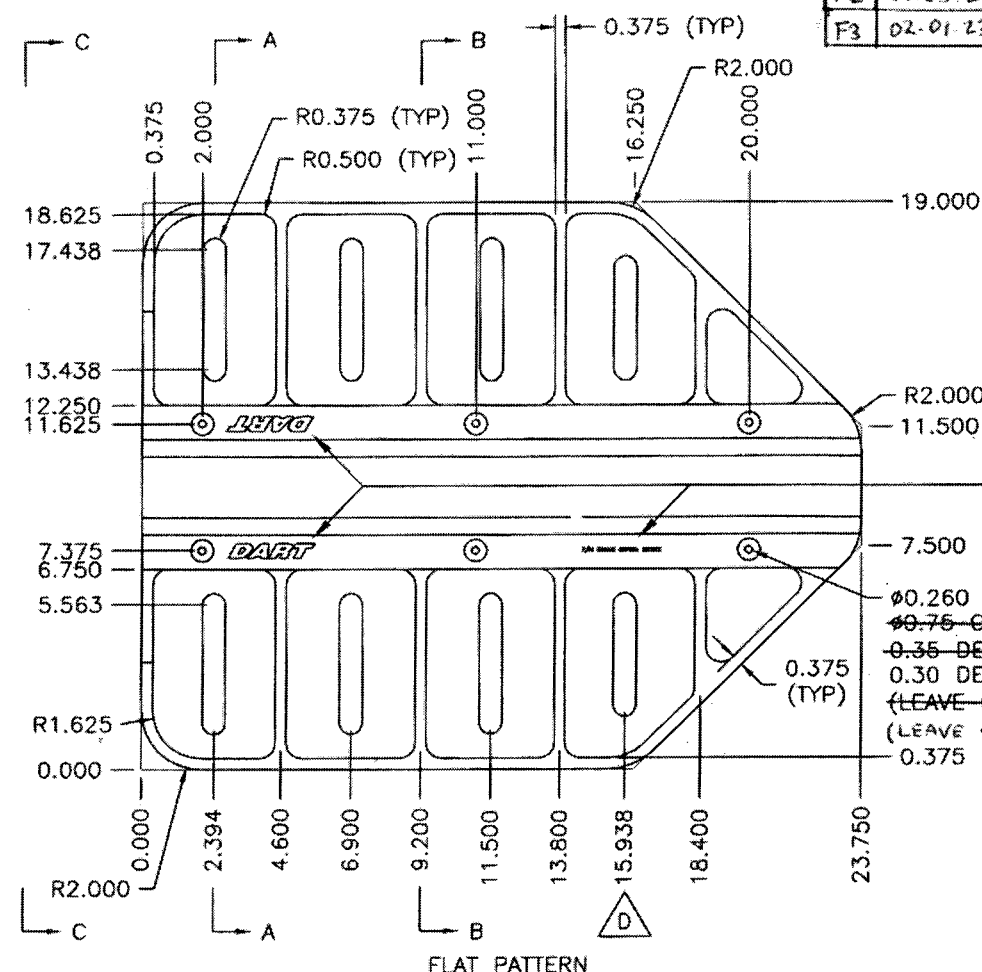


ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

#73981

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED KE	APPROVED KE	
DATE 98.05.12	TITLE BEARPAW	REV. F SHEET 1 OF 2 SCALE 1:6
A	95.10.31	NEW ISSUE
B	96.01.24	RE-DESIGN
C	96.03.26	CHANGE BORE AND C'BORE DEPTH
D	96.06.04	MOVE SLOT
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N

EFFECTIVE	DEOS
9143	



D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

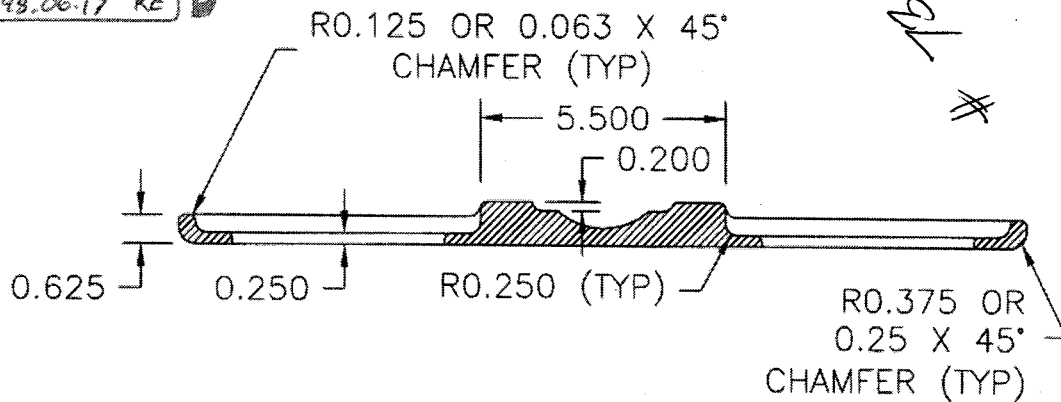
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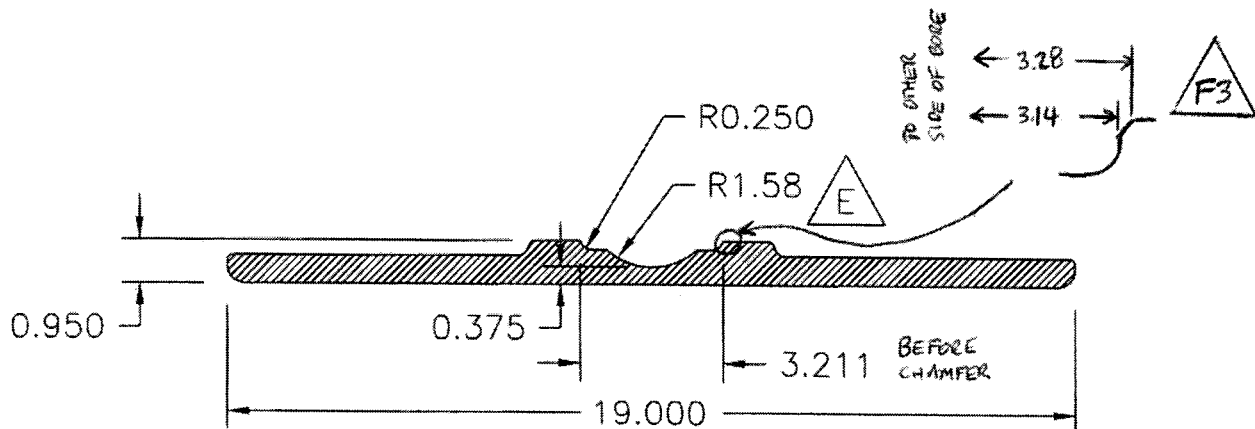


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

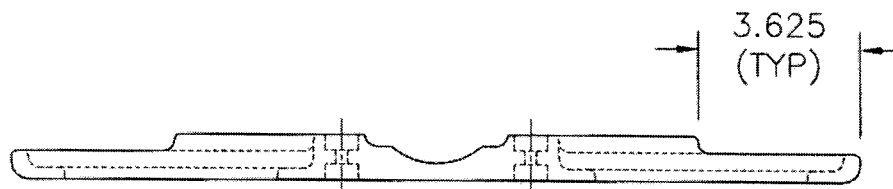
RELEASED
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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